

Work Order ID 131851

131851

Page 1

Tuesday, April 21, 2015 2:07:14 PM

Item ID: D4271-027 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: End Fitting Assembly Aft Beam
 Start Date: 4/20/15 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 4/20/15 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: MCS Date: 15-04-22 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4271	D

100 0.00
 100
 Small Fab Memo 0.00
 Small Fab Assemble as per dwg D4271
 REAM HOLE AS PER DWG
 CUT RIVET AT 1.130"
 C' SINK AT .220" X100 DEG FOR HOLE OPPOSITE TO HEAD

110 0.00
 110
 QC Memo 0.00
 Quality Control

120 0.00
 120
 Packaging Memo 0.00
 Packaging

DAS
36
9-89
15/04/23

DAS
38
9-89

APR 23 2015

DAS
35
9-89
APR 22 2015
27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Tuesday, April 21, 2015 2:07:14 PM

Page 2

MCS 1504-27

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Past Expiry Date ☐	Manufacturing Process ☐																								
Misidentified ☐	Past Due ☐	OTHER : _____																							

Picklist Print

Tuesday, April 21, 2015 2:07:13 PM

Page 1

Work Order ID: 131851

131851

Parent Item: D4271-027

D4271-027

Parent Item Name: End Fitting Assembly Aft Beam

Start Date: 4/20/15

Required Date: 4/20/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP revA 11.07.20 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4148-3		Manufactured	No			100	Each	7.0000	1	1			
D4148-3									**			15/04/23	DAS 36 389
Stud Receiver, Lower													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST103a				7					
				128248				3					
				131145				4					
D4148-5		Manufactured	No			100	Each	16.0000	1	1			
D4148-5									**			15/04/23	DAS 36 389
Eyebolt Stud													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST094				16					
				128249				4					
				130603				12					
D4281-3		Manufactured	No			100	Each	9.0000	1	1			
D4281-3									**			15/04/23	DAS 36 389
Spacer													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST097				9					
				123097				9					
D4419-3		Manufactured	No			100	Each	9.0000	2	2			
D4419-3									**			15/04/23	DAS 36 9-89
Aft Support Plate													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST105				9					
				122964				9					

DQA: _____ Date: _____



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Parent Item: D4271-027

D4271-027

Parent Item Name: End Fitting Assembly Aft Beam

Start Date: 4/20/15

Required Date: 4/20/15

Start Qty: 1.00

Required Qty: 1.00

AN4C13A Purchased No

100 Each 46.0000 2 2

AN4C13A
BOLT

**

15/04/23 DAS 36 9-89

Location	Loc Qty	Loc Code
ST344	46	
131677	38	
m128818	8	

4

MS20427M4-20 Purchased No

100 Each 98.0000 1 1

MS20427M4-20
RIVET

**

15/04/23 DAS 36 9-89

Location	Loc Qty	Loc Code
GA	98	
118429	98	

2

MS20615-4M18 Purchased No

100 Each 551.0000 10 10

MS20615-4M18
Rivet

**

15/04/23 DAS 36 9-89

Location	Loc Qty	Loc Code
CCK003	370	
m123810	370	
GA	74	
m130358	74	
ST307	107	
125162	107	

20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Parent Item Name: End Fitting Assembly Aft Beam

Start Date: 4/20/15

Required Date: 4/20/15

Start Qty: 1.00

Required Qty: 1.00

DAS

MS21043-4

Purchased

No

100

Each

1,083.000

2

2

**

15/04/23

36
9-89

MS21043-4

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

370

m128798

370

ST304

673

m128818

34

m131697

639

4

NAS1149C0432R

Purchased

No

100

Each

3,551.000

4

4

**

15/04/23

DAS
36
9-89

NAS1149C0432R

WASHER

Location

Loc Qty

Loc Code

GA

2238

m125807

476

m131467

1762

ST271

1313

m131452

1313

8

DQA: _____ Date: _____



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